Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 76423
Aircraft: Eurocopter Model: AS350
Description: Large Mount Hoop
Supplier: Aero Design
Color: N/A
WO#: 2014-19 PO# N/A

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2014-19

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Long Cargo Basket	78410-01	1	78401-49	New

12. Remarks

Modified with walkway on lid and front end cutout on LH side IAW DCL704, Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	14 Mar 2014		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

HTC / HELI EXPRESS

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
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AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO2014-19

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Long Cargo Basket	78410-01	1	78401-50	New

12. Remarks

Modified with walkway on lid IAW DCL704; Black

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.
13b. Signature: Jeff Clarke AD02	13c. Approved Organization Number: AMF 73-04
13d. Name: Jeff Clarke - AD02	13e. Date (dd/mmm/yyyy): 10 Apr 2014
14b. Signature	14c. Approved Organization Number
14d. Name	14e. Date (dd/mmm/yyyy)

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

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CAAD COX / WTS

CARGO BASKET HOOP FABRICATION - 76423

General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop
84262, Revision 1 – Handle Bracket Assembly

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-19 **Complete** (initial or SCA #)

Date Open: 19 Feb 2014

1. ½ Hoop Fabrication – ½" hoop — AQ06
   a. Cut ½" x 0.035 material to 22.0", square ends.
   b. Record material PO on attached material list.
   c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
   d. Remove writing on tubes with acetone and scotch bright.
   e. On the hoop bending fixture, set the following stops:
      i. Upper tube stop: ??"
      ii. Lower bend stop: 12mm
   f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
   g. Slide shim all the way forward on bender to secure tube in die
   h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
   i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
   j. Check for:
      i. hoop height: 17 1/8" (Outside to outside)
      ii. adjust upper stop for height if required

2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01) — AQ06
   a. Start with ½" half hoop from step 1.
   b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
   c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
      i. locate 0.23" from edge (within tolerance specified on drawing).
   d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
   e. Tag in process hoop(s) and place into stock.

Complete
(initial or SCA #)

3. ½ Hoop Fabrication – 1" hoop JA 7/16 AD06
   a. Cut 1" x 0.065 material to ~~28.0~~", one end square, one end @ 16 degrees.
   b. Record material PO on attached material list.
   c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
   d. Remove writing on tubes with acetone and scotch bright.
   e. On the hoop bending fixture, set the following stops:
      i. Upper tube stop: ??" 20 9/16
      ii. Lower bend stop:?? 350 Dish
   f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
   g. Slide shim all the way forward on bender to secure tube in die
   h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
   i. Check tube bend for angle using hoop jig. Adjust stops if required.
   j. Check for:
      i. hoop height from jig
      ii. adjust upper stop for height if required
      iii. length to allow 60 degree cut.
   k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
   l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

4. ½ Hoop Machining – 1" hoop AD06
   a. Start with 1" ½ hoop as stock.
   b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
   c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
   d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
   e. Set tube in vise with 60 degree end on right.
   f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
   g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
   h. Tag in process hoop(s) and place into stock.

5. Joint Preparation AD06
   a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

6. Welding – Lugs AD-05
   a. Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
   b. TIG weld all around both sides of lugs. 2 places.
   c. Record lug and welding rod PO/WO on attached material list.

Complete
(initial or SCA #)

7. Welding – Handle Bushings – 84262-01 AD-05
    a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
    b. TIG weld bushing both sides, 2 bushings per hoop.
    c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly AD-05
    a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
    b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
    c. TIG weld around ½" hoop in slot.
    d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
    e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection AD04
    a. Run 3/8-24 tap through welded lugs.
    b. Grind inside surfaces flush at lugs and slot in 1" tube.
    c. Inspect hoop for conformity to drawing.
    d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-19

Date Opened: 19 - Feb 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Hoops

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1			**76421-01**	**Hoop - standard**	4130 Steel, ½" x 0.035 Sqr. Tube	~~12123~~ 14009
			76423-07	**Hoop - attachment**		
Step 1				*1/2 Hoop Fabrication - 1/2" hoop*		
	. 1		--	1/2" Tube - hoop	4130 Steel, ½" x 0.035 Sqr. Tube	12123
Step 2				*Machining*	*None*	
Step 3				*1/2 Hoop Fabrication - 1" hoop*		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	12023
Step 4				*Machining*	*None*	
Step 5				*Joint Preparation*	*None*	
				Welding		
Step 6	. 2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	13005
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	7088 ** SPA Vegas
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	9020/17131
	. A/R		--	Welding Rod	ER70S-2	
Step 9				*Finishing and Inspection*	*None*	

WO 2014-19
AS350 long x2

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 9014-19

Date Open: 19 Feb 2014

#1 #2

1. Rim Assembly – Basket Body — AD06 AD06
   a. Cut and fit ¾" x 0.035 material to fit rim jig.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.
   d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
   e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly. — AD-05 AD-05
   a. Record welding rod PO on attached material list.
   b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection — AD06 AD06
   a. Rim for complete welds

4. Frame assembly – body — AD06 AD06
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
   b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
   c. Pull required hoops from stock - standard, attachment, handle.
      i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
      ii. Ensure vent hole is located at centre of tube to vent spine tubes.
   d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
      i. Ensure correct order and orientation of hoops. Refer to drawing.
         1. Attachment lugs are on inboard side.
         2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
      ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
      iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
      iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
      v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
   e. Cut ½" x 0.035 material to fit spine jig.
   f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
      i. Refer to applicable drawing for position, not required on some baskets.
   g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
   h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
   i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly. AD-05 AD-05
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

6. Inspection AD06 AD06
    a. Frame assembly for complete welds.

7. Mesh assembly. AD06 AD06
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

Complete
(initial or SCA #)

8. Weld mesh to frame assembly per drawing. AD-05 AD-05
    a. Ensure lug locating jig is in place prior to welding.
    b. General welding requirements for all baskets, MIG welding:
        i. Every intersection at top edges.
        ii. Every intersection at ends.
        iii. First 5 intersections down on hoops, then every second intersection.
        iv. Every intersection along spine.
        v. Extra large baskets – every intersection along corner.
        vi. Every intersection around ends
        vii. Every intersection along struts (if applicable)
    c. Bend and trim cells bent in to fit mesh as required and weld in position.
    d. Grind high spots off body mesh welds on ends before welding end mesh.
    e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
    f. Record welding rod PO on attached material list.

9. Weld basket components AD-05 AD-05
    a. TIG weld lid prop bushing(s), one or two per drawing.
        i. Record welding rod PO on attached material list.
        ii. Record lip prop bushing WO on attached material list.
    b. TIG weld caps to close top of 1" hoops as applicable.
    c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
        i. Cut inboard rim on aft end. Grind flush with hoops.
        ii. TIG weld caps on open tubes.
        iii. Record cap material PO on attached material list.
    d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
        i. Record welding rod PO on attached material list.
        ii. Record placard bracket WO on attached material list.

10. Clean up APOC ADOC
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    c. Drill #9 through lid prop bushing(s). De-burr hole(s).
    d. Remove surface rust with scotch-brite pad.

11. Final Inspection dR dR
    To be completed by a different person than the previous steps.
    a. Basket body assembly for complete welds, and required minimum mesh weld locations.
    b. Filled vent holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
        i. Hoops for height.
        ii. Rim for width and length and alignment.
        iii. Lid prop lugs in correct ends.
        iv. Fore/aft strut in hoop if required by drawing.
    d. Material lists complete.

Complete
(initial or SCA #)

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating — AQ06 AQ06

a. Parts are to be powder coated ~~white~~ Black DK in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2014-19

Date Opened: 19 Feb 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO	
			78411-01	**Basket Assembly**			
Step 1				*Rim Assembly*			
	.2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	13087	13087
	.2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	13087	13087
Step 2				*Weld Rim Assembly*			
	.A/R		--	Welding Rod	ER70S-2 TIG Rod	11122	11122
Step 3				*Inspection - Rim*	*None*		
Step 4				*Frame Assembly*			
	.4		76421-01	Hoop - standard	4130 Steel, ½" x 0.035 Sqr. Tube	14009	14009
	.2		76423-01	Attachment hoop (aft)		14006	14006
	.5		--	1/2" Tube - spine	4130 Steel, ½" x 0.035 Sqr. Tube	14009	14009
Step 4.g.		70406	70406-01	Option: Front End Cutout			
			70406-03	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube		
			70406-04	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube		
Step 5				*Weld Frame Assembly*			
	.A/R		--	Welding Rod	ER70S-2 TIG Rod	11122	11122
Step 6				*Inspection - Frame Assembly*	*None*		
Step 7				*Mesh Assembly*			
	.1		--	Mesh (Body - 48" x 92.25")	3/4-16F Expanded Mild Steel sheet	13078	13078
	.2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	13078	13078
Step 8				*Weld Mesh*			
	.A/R		--	Welding Rod	ER70S-6 MIG Wire	14005	14005

Work Order: 2014-19

Date Opened: 19-Feb 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO	
Step 9				*Weld Basket Components*			
Step 9.a.	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2013-55	2013-55
	. A/R		--	Welding Rod	ER308L TIG Rod	14005	14005
Step 9.b.	. 2		--	Cap	1018 Mild Steel, 0.032" Sheet	9010	9010
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005	14005
Step 10				*Clean Up*	*None*		
Step 11				*Inspection - Final Assembly*	*None*		
Step 12				Powder Coating			

CARGO BASKET LID FABRICATION - COMMON

WO 2014-19
AS350 Long (2)

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 0 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 1 – Short Basket
69812, Revision 3 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 0 – Standard Basket

Bell Medium – left or right
75112, Revision 0 – Standard Basket
95512, Revision 0 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
70405, Revision 3 – Walkway
70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-19

Date Open: 19 Feb 2014

1. Rim Assembly – Basket Lid — ~~ADO6~~ ~~ADO6~~
   a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly — AD-05 AD-05
   a. Record welding rod PO on attached material list.

3. Inspection — N/A N/A
   a. ~~Rim for complete welds~~

4. Frame assembly – Lid — ~~AD06~~ ~~ADO6~~
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
   b. Insert rim from step 2 into jig.
   c. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.
   d. Record material PO on attached material list.
   e. Remove writing on tubes with acetone and scotch bright.
   f. Drill vent holes into rim to vent cross members into rim.
   g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification — ~~AD06~~ ~~ADO6~~
   a. Fit cross members to rim in accordance with step 4.
   b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
   c. Cut ½" x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
   d. Drill vent holes into cross members at walkway stingers.
   e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly. — AD-05 AD-05 ~~AD05~~
   a. Record welding rod PO on attached material list.
   b. Jigs must remain in place for as long as practical during welding.

7. Inspection — ~~ADO6~~
   a. Frame assembly for complete welds.

Complete
(initial or SCA #)

8. Mesh assembly. AD06 AD06
   Note: 95912 (Bell 429) does not have mesh. Skip to step 10.
   a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
   b. Cut mesh to size for lid.
   c. Remove surface rust with scotch-brite.
   d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing. AD-05 AD-05
   a. General welding requirements for all lids:
      i. Every intersection on all edges.
      ii. First 5 intersections along cross members, then every second intersection.
   b. MIG weld both short sides.
   c. Clamp lid over spacer at centre of lid to pre-tension mesh.
      i. ¾" for lids under 76"
      ii. 1" (check) for lids over 76"
   d. Weld remainder of mesh as indicated in a.
   e. Record welding rod PO on attached material list.

10. Weld lid components. AD-05 AD-05
   a. Handle brackets, locate in accordance with drawing.
      i. Standard location: ¼" outside of last cross member on both ends.
      ii. Record handle bracket WO and welding rod PO on attached material list.
   b. Lid prop bushing(s).
      i. one or two in accordance with drawing.
      ii. Record lip prop bushing WO and welding rod PO on attached material list.
   c. Placard bracket. – not installed on 95912 (Bell 429)
      i. Locate on cross member to set bracket in centre bay of lid.
      ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up AD06 AD06
   a. Grind high spots off mesh welds.
   b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
   c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
   d. Drill #9 through lid prop bushing(s). De-burr hole(s).
   e. Drill for lid bumpers using 1/4" (#3) centre drill.
      i. 3 places for lids under 76"
      ii. 4 places for lids over 76"
   f. Remove surface rust with scotch-brite pad.

12. Final Inspection
   To be completed by a different person than the previous steps. AK AK
   a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
   b. Material lists complete.
   c. Overall condition and conformity to drawing(s).

Complete
(initial or SCA #)

13. Powder Coating — AQ06 SCA06

    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-19

Date Opened: 19 FEB -2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO	
			78412-01	**Lid Assembly**		#1	
Step 1				*Rim Assembly*			
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	12123	12123
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	12123	12123
Step 2				*Weld Rim Assembly*			
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	11122	11122
Step 3				*Inspection - Rim*	*None*		
Step 4				*Frame Assembly*			
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, ¾" x 0.035 Sqr. Tube	12123	12123
Step 5		70405		*Option: Frame Assembly - with walkway*			
	. 8		--	1/2" Tube - walkway	4130 Steel, ½" x 0.035 Sqr. Tube	14009	14009
Step 6				*Weld Frame Assembly*			
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	11122	11122
Step 7				*Inspection - Frame Assembly*	*None*		
Step 8				*Mesh Assembly*			
	. 1		--	Mesh (lid - 92.5" x 22")	3/4-16F Expanded Mild Steel sheet	11032	11032
Step 9				*Weld Mesh*			
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	14005	14005

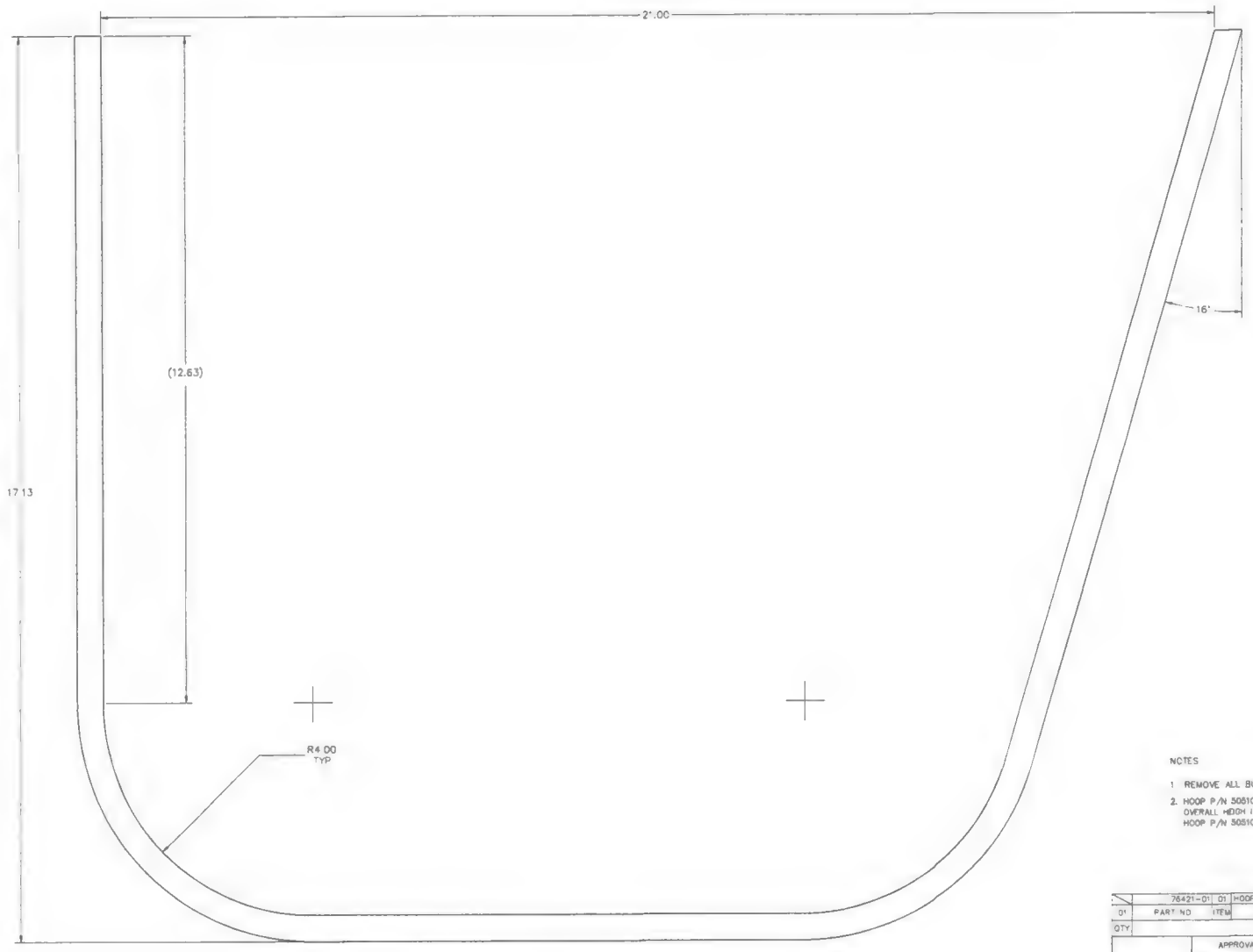
Work Order: 2014-19

Date Opened: 19 FEB 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO	
Step 10				*Weld Lid Components*			
	. 1	84262	84262-01	Upper Handle Bracket Assembly			
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet		
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod		
	. A/R		--	Welding Rod	ER308L TIG Rod	14005	14005
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, ½" Dia.	2014-09	2014-09
	. A/R		--	Welding Rod	ER308L TIG Rod	14005	14005
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	11122	11122
Step 11				*Clean Up*			
Step 12				*Inspection - Final Assembly*			
Step 13				Powder Coating			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	-RR	24 JAN 08



(01) HOOP
SCALE 1 : 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. HOOP P/N 50510-01 IS USED AS A DIRECT REPLACEMENT FOR HOOP P/N 76421-01. OVERALL HEIGHT IS REDUCED BY 1.38 IN. THERE ARE NO OTHER CHANGES. HOOP P/N 50510-01 IS USED ON BASKET S/N 76401-01, 76401-02, 78401-01, 77601-01, 77602-01 ONLY.

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
01	76421-01	01	HOOP	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE

LIST OF MATERIALS

APPROVALS		DATE
DRAWN	R. RATHWELL	24 JAN 08
CHECKED	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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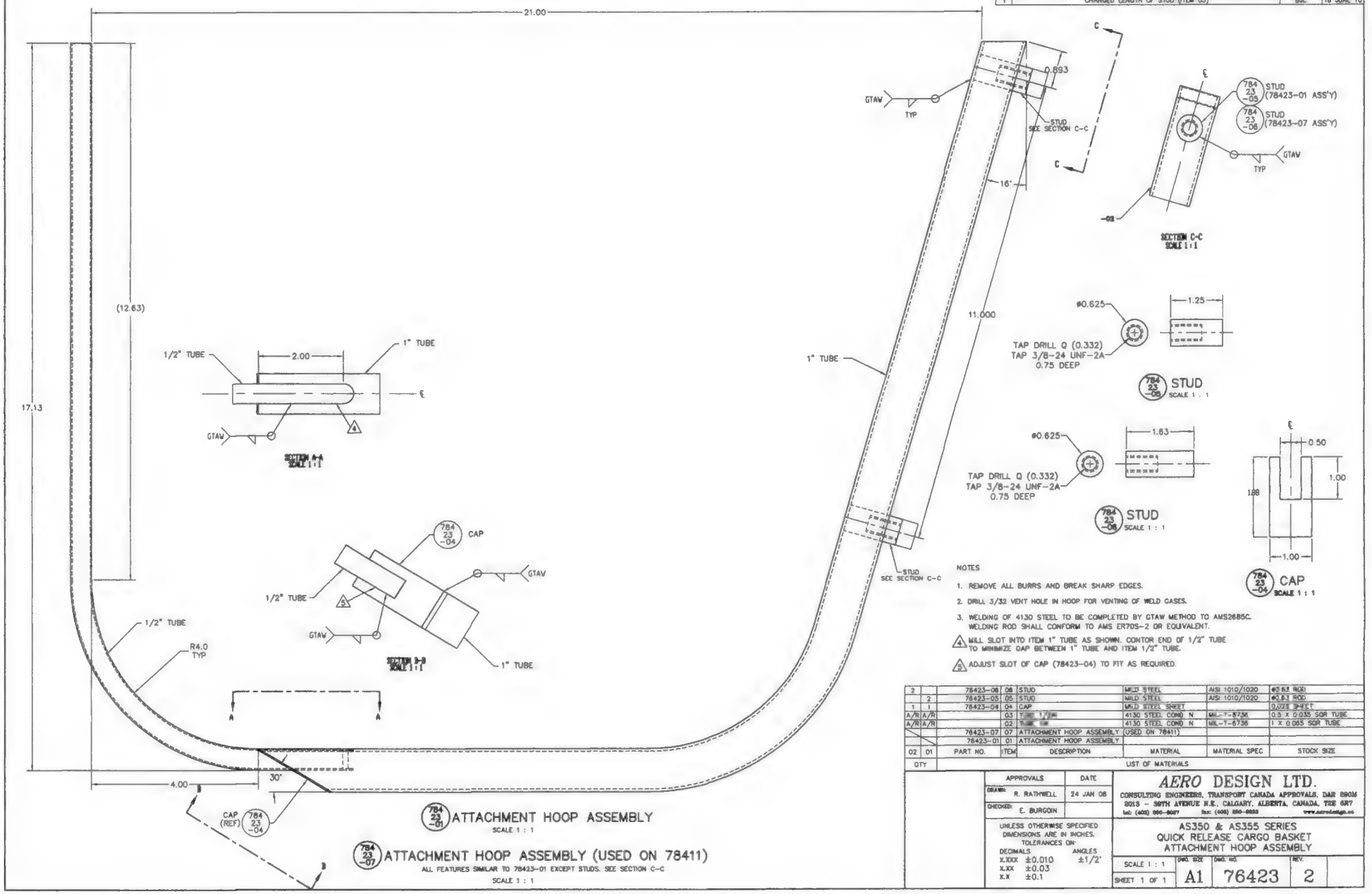
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
HOOP

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV
SHEET 1 OF 1	A1	76421	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08
1	ADDED 78423-07 ASS'Y AND 78423-08 PART	RR	05 MAR 09
1	CHANGED LENGTH OF STUD (ITEM 05)	BJC	16 JUNE 10



784 23 -01 ATTACHMENT HOOP ASSEMBLY
SCALE 1 : 1

784 23 -07 ATTACHMENT HOOP ASSEMBLY (USED ON 78411)
ALL FEATURES SIMILAR TO 78423-01 EXCEPT STUDS. SEE SECTION C-C
SCALE 1 : 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS ER70S-2 OR EQUIVALENT.

4 MILL SLOT INTO ITEM 1" TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.

5 ADJUST SLOT OF CAP (78423-04) TO FIT AS REQUIRED.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
02	78423-08	08	STUD	MILD STEEL	AISI 1010/1020	ø3.63 ROD
2	78423-05	05	STUD	MILD STEEL	AISI 1010/1020	ø2.63 ROD
1	78423-04	04	CAP	MILD STEEL SHEET		0.025 SHEET
A/R		03	TUBE 1"	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 SQR TUBE
A/R		02	TUBE 1/2"	4130 STEEL COND N	MIL-T-6736	1 X 0.065 SQR TUBE
	78423-07	07	ATTACHMENT HOOP ASSEMBLY	(USED ON 78411)		
	78423-01	01	ATTACHMENT HOOP ASSEMBLY			

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	R. RATHWELL	24 JAN 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

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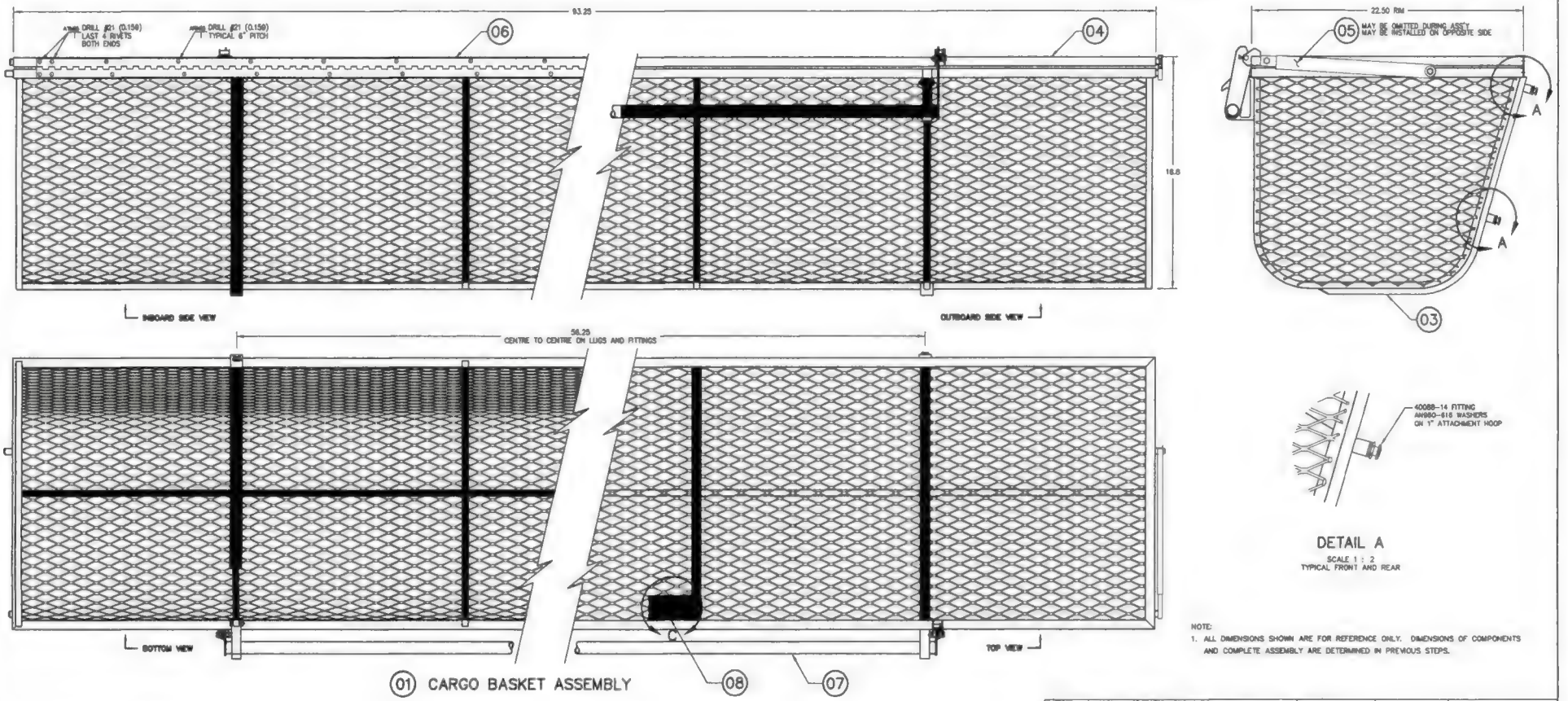
AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
ATTACHMENT HOOP ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	76423	2

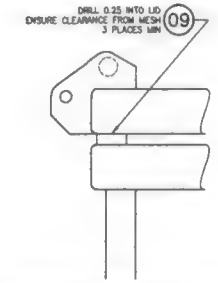
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BJC	27 JAN 10



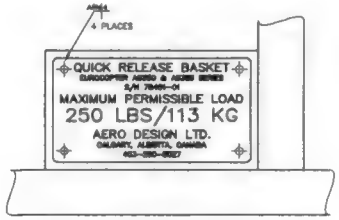
01 CARGO BASKET ASSEMBLY

DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

A/R	AN960-616		WASHER			
4	40088-14		FITTING	ANCRA		
8	CR3523-5-02		CHERRY RIVET			
A/R	CR3213-5-02		CHERRY RIVET			
4	CR3213-4-02		CHERRY RIVET			
3	49205-14	09	BUMPER	ARGUT INDUSTRIES		
1	78427-01	08	PLACARD			
1	84255-01	07	HANDLE BAR INSTALLATION			
A/R	MS20001P4	06	PIANO HINGE			92 LONG
1	36280-01	05	BRACE ASSEMBLY			
1	78412-01	04	LID ASSEMBLY			
1	78411-01	03	BASKET BODY ASSEMBLY			
		02				
	78410-01	01	CARGO BASKET ASSEMBLY			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. NAS 523
DASH NO. FOR DIAMETER
N=MFD. HEAD NEAR SIDE
F=MFD. HEAD FAR SIDE
C=COUNTERSUNK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED
DASH NO. FOR LENGTH
BASIC CODES:
BJ = MS20470AD
BB = MS20426AD
ARN = CR3213
ATM = CR3523
INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS	DATE
DRAWN: R. RATHWELL	19 FEB 08
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES ±1/2°

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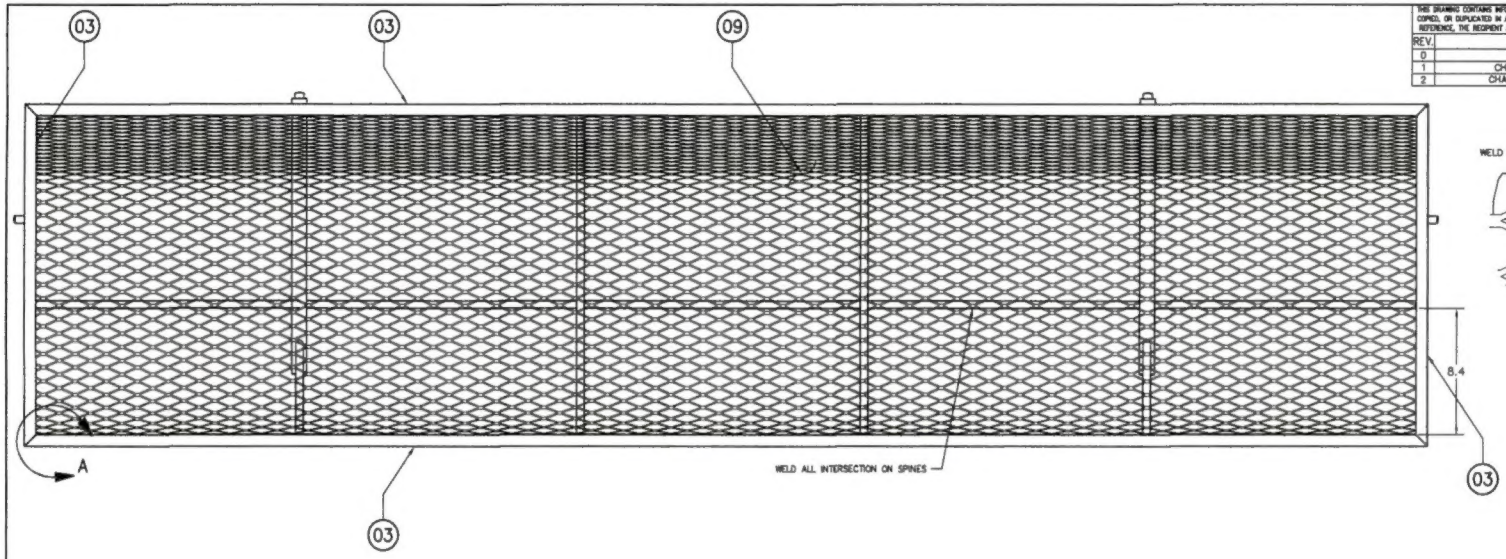
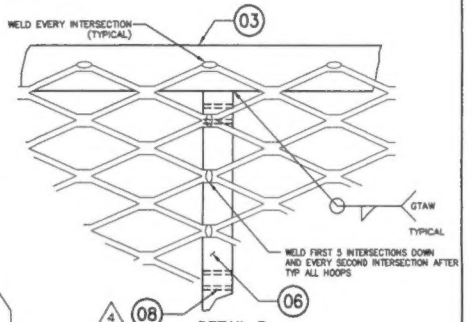
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE SKI BASKET
BASKET ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78410	1

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	25 JAN 08
1	CHANGED ATTACH HOOP FROM 76423-01 TO 76423-07	RR	05 MAR 09
2	CHANGED HANDLE BRACKET, REMOVED ALTERNATE BASKET	BJC	28 JAN 10

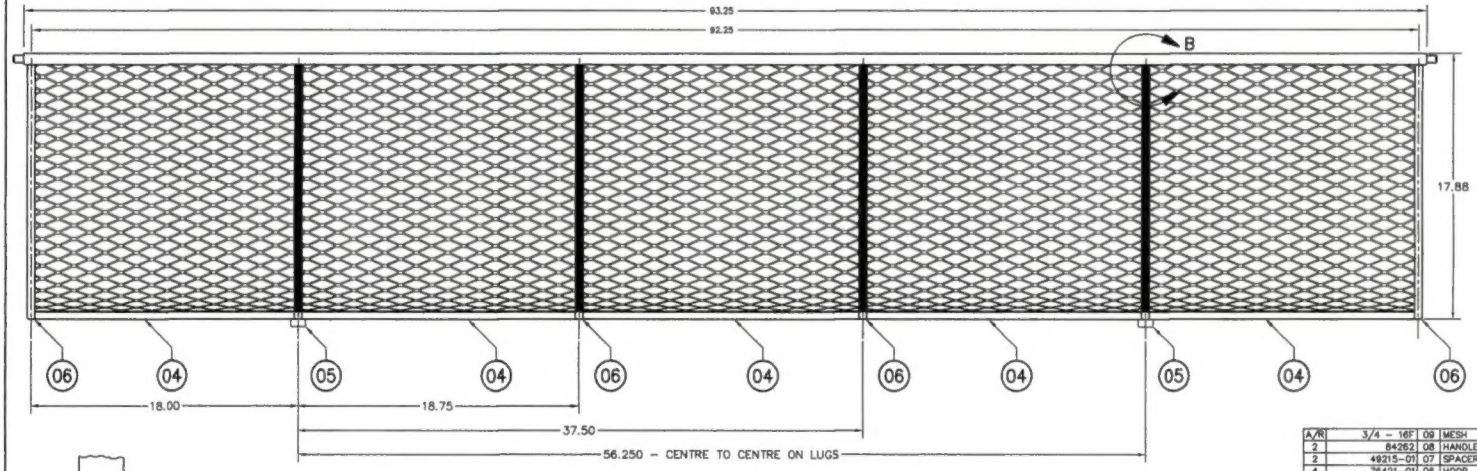


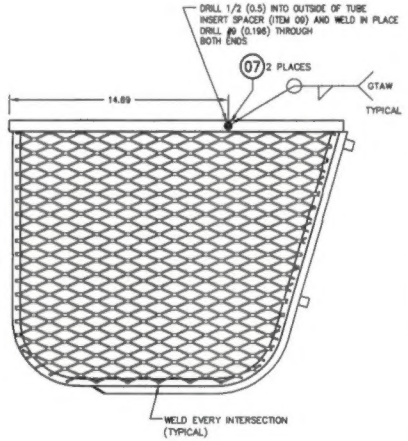


DETAIL B

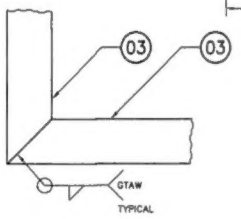
SCALE 1:1

VIEW LOOKING AT INNER SURFACE OF BAKSET





(01) BASKET BODY ASSEMBLY



DETAIL A

SCALE 1:1

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL 3/32 VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. INSTALL ITEM 8 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 TYP 2 PLACES.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
A/R	3/4 - 16F	09	MESH	STEEL	STEEL	
2	84262	08	HANDLE BRACKET ASSEMBLY			
2	49215-01	07	SPACER			
4	76421-01	06	HOOP			
2	76423-07	05	ATTACHMENT HOOP			
A/R		04	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	1/2 X 0.032 SQR TUBE
A/R		03	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	3/4 X 0.032 SQR TUBE
		02				
	78411-01	01	BASKET BODY ASSEMBLY			

APPROVALS		DATE
DRAWN:	R. RATHWELL	25 JAN 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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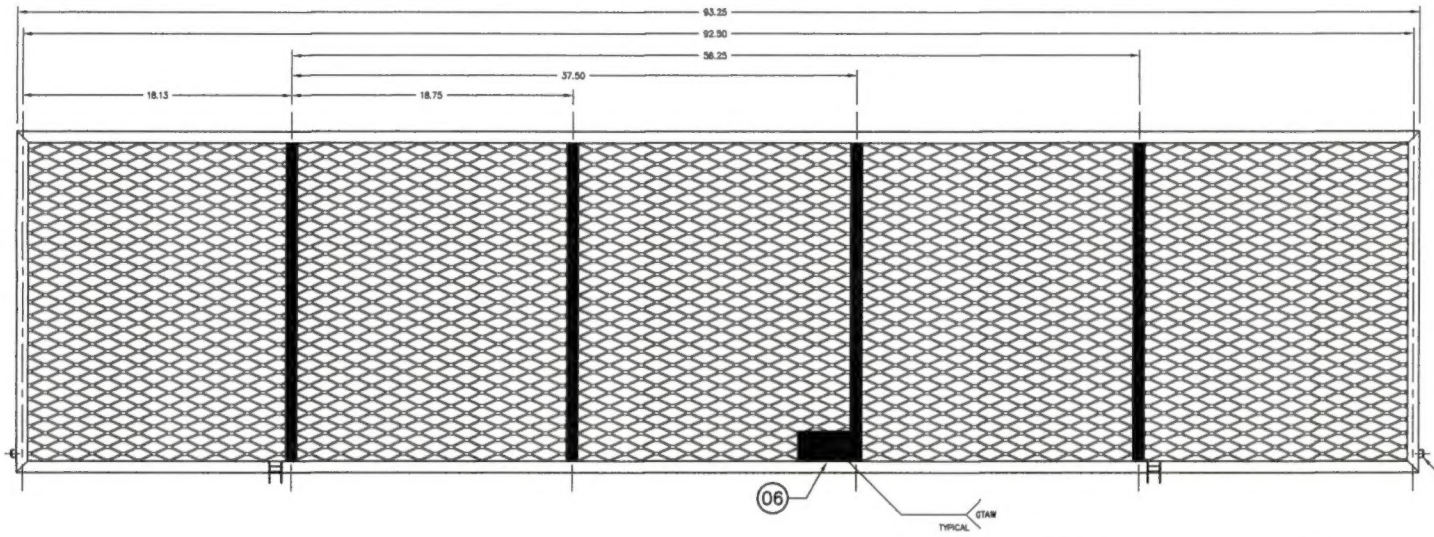
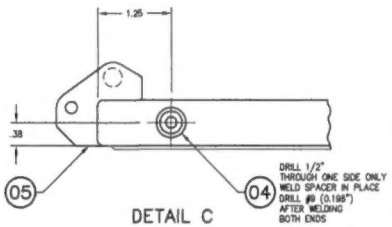
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78411	2

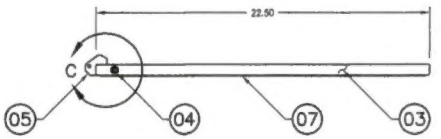
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE BRACKETS, REMOVE ALTERNATE LID	BJC	28 JAN 10

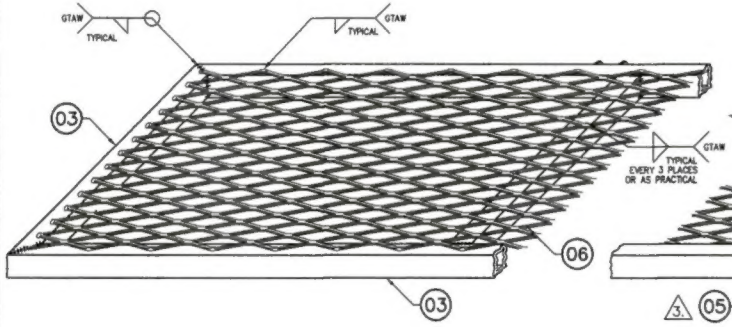




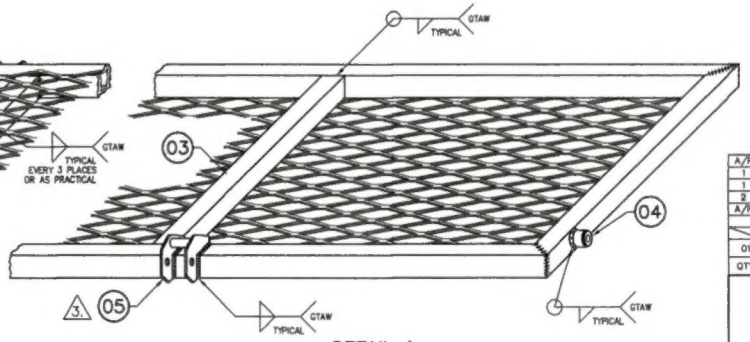
DETAIL C
SCALE 1 : 1

01 BASKET LID ASSEMBLY





DETAIL B
LOOKING AT BOTTOM



DETAIL A
LOOKING AT TOP

NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. INSTALL (ITEM 5 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 36262 TYP 2 PLACES.
4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
A/R	3/4-16F	07	MESH			
1	36204-10	06	PLACARD BRACKET			
1	84262-01	05	UPPER HANDLE BRACKET ASSY			
2	49216-01	04	SPACER			
A/R		03	SQUARE TUBE	4130 STEEL COND N.	MIL-T-6736	3/4 X 0.035 SQR TUBE
		02				
	78412-01	01	BASKET LID ASSEMBLY			

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	R. RATHWELL	19 FEB 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2"

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CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 8909
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250-8087 fax: (403) 250-8393 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET LID ASSEMBLY

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 4	A1	78412	1
SHEET 1 OF 1			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	JAN 27/10

NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:
   "QUICK RELEASE BASKET" – 0.125 HIGH
   "EUROCOPTER AS350 & AS355 SERIES" – 0.080 HIGH
   "S/N 78401-XX" – 0.080 HIGH
   "MAXIMUM PERMISSIBLE LOAD" – 0.125 HIGH
   "250 LBS/113 KG" – 0.200 HIGH
   "AERO DESIGN LTD." – 0.125 HIGH
   "CALGARY, ALBERTA, CANADA" – 0.080 HIGH
   "403-250-8027" – 0.080 HIGH

(01) PLACARD

PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: R. RATHWELL	18 FEB 08
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
2013 – 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
PLACARD

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78427	1

Aero Design
Parts Distribution Sheet

WO# 2014-19

From PO or WO #	Quantity	Description	Part Number	For WO #
13066	2	Tread Plate	5 7/8	
See work	order	packages		

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013